

Work Order ID 63540

Thursday, November 04, 2010 9:58:56 AM



Page 1

Item ID: D3065-1	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Step Spacer					
Start Date: 11/4/2010	Start Qty: 40.00		Cust Item ID:		
Required Date: 11/19/2010	Req'd Qty: 40.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date: 10-11-04	Tooling:	Date:
	QC:	Date:	SPC (Y/N):	Date:

Run	Start	
	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3065	Rev B								

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3065 <input type="checkbox"/> Dwg Rev: B <input type="checkbox"/> Prog Rev: B <input type="checkbox"/> 2- Deburr as required								
2624 . 540									
110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									
120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

B10-11-22

40

B10-11-22

810/11/22

counted
x40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D3065-1

Accept



Setup Start



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Stop



Item Name: Step Spacer

Start Date: 11/4/2010

Start Qty: 40.00



Cust Item ID:

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Req'd Qty: 40.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

Deburr if necessary.

0.00

0.00

N/A

EP 10/11/22

140



Brake NC

Brake NC

NC BRAKE

Memo

Bend as per Dwg D3065

0.00

0.00

SB 10/11/22

EP 10/11/22

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

SB 10/11/22

count
X40

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	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				40	9		
170 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
180 Packaging Packaging	Identify as per dwg & Stock Location: <u>CA</u> Memo	0.00 0.00							

=) H 10/11/29

H0 & BL 10-11-29

EP 10/12/08 (40)

W/O:		WORK ORDER CHANGES					
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Item Name: Step Spacer

Start Date: 11/4/2010

Start Qty: 40.00



Cust Item ID:

Required Date: 11/19/2010

Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/12/08 *[Signature]*
MF
10-12-08.

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Picklist Print

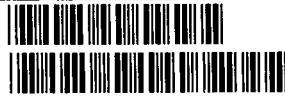
Thursday, November 04, 2010 9:58:59 AM

Page 1

Work Order ID: 63540

Parent Item: D3065-1

Parent Item Name: Step Spacer



Start Date: 11/4/2010

Required Date: 11/19/2010

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP: ☐C02.11.01 Incorporated D3066-1 IPP ☐KJ/RP ☐
IPP: ☐D06.04.25 Water jet EC ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.040

Purchased

No

100

sf

280.8400

0.1238

5.212632



1810-1-02

2024-T3 .040 sheet

Location

Loc Qty

Loc Code

MAT

71.6

114415

71.6

114415

MAT22

209.24

110305

21.93

111786

9.66

112291

28.25

112331

52

113162

97.4

40

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DART AEROSPACE LTD		Work Order:	43540
Description: Step Spacer		Part Number:	D3065-1
Inspection Dwg: D3065 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.250	+/-0.010	.252	*		V RB 02	
2.093	+/-0.010	2.095	*		V	
3.936	+/-0.010	3.936	*		V	
4.186	+/-0.010	4.193	*		V	
0.587	+/-0.010	.586	*		V	
Ø0.128	+0.005/-0.001	.131	*		V	
R0.125	+/-0.010	.125	*		R. G.	
3.465	+/-0.010	3.457	*		V	
Ø1.250	+0.012/-0.001	1.253	*		V	
0.368	+/-0.010	.366	*		V	
0.871 (Pitch)	+/-0.005	.872	*		V	
0.040	+/-0.010	.040	*		V	

Measured by: RB	Audited by: S	Prototype Approval:
Date: 10-11-22	Date: 10/11/22	Date:

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	KJ/RF	
B	06.06.23	Dwg Rev. changed	KJ/JLM	
C	07.02.07	Dimension 0.040 added	KJ/JLM	

W/O:		WORK ORDER CHANGES					
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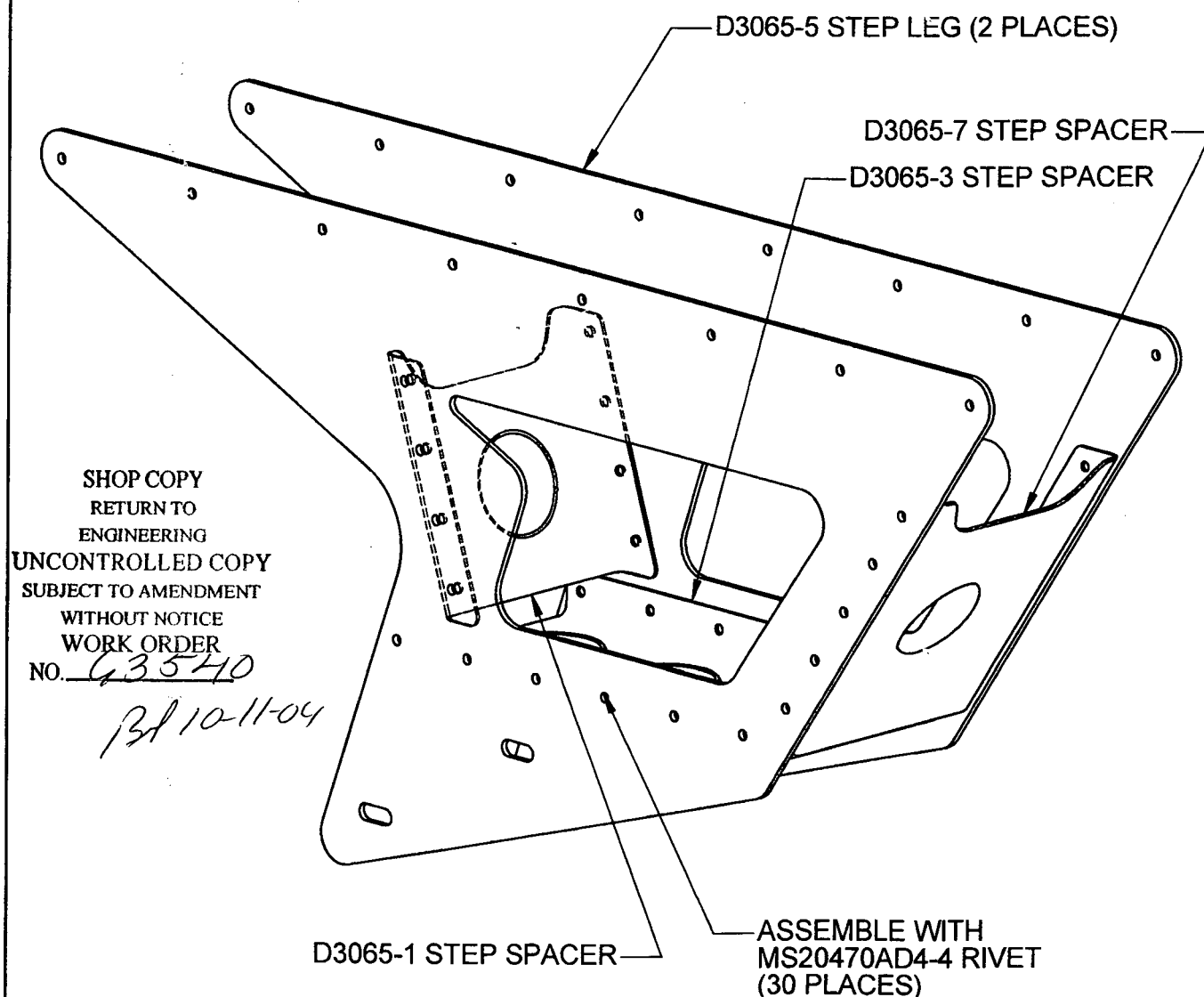
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DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED*06.06.20* *[Signature]***D3065-041 STEP LEG ASSEMBLY****COPYRIGHT © 2002 BY DART AEROSPACE LTD.**

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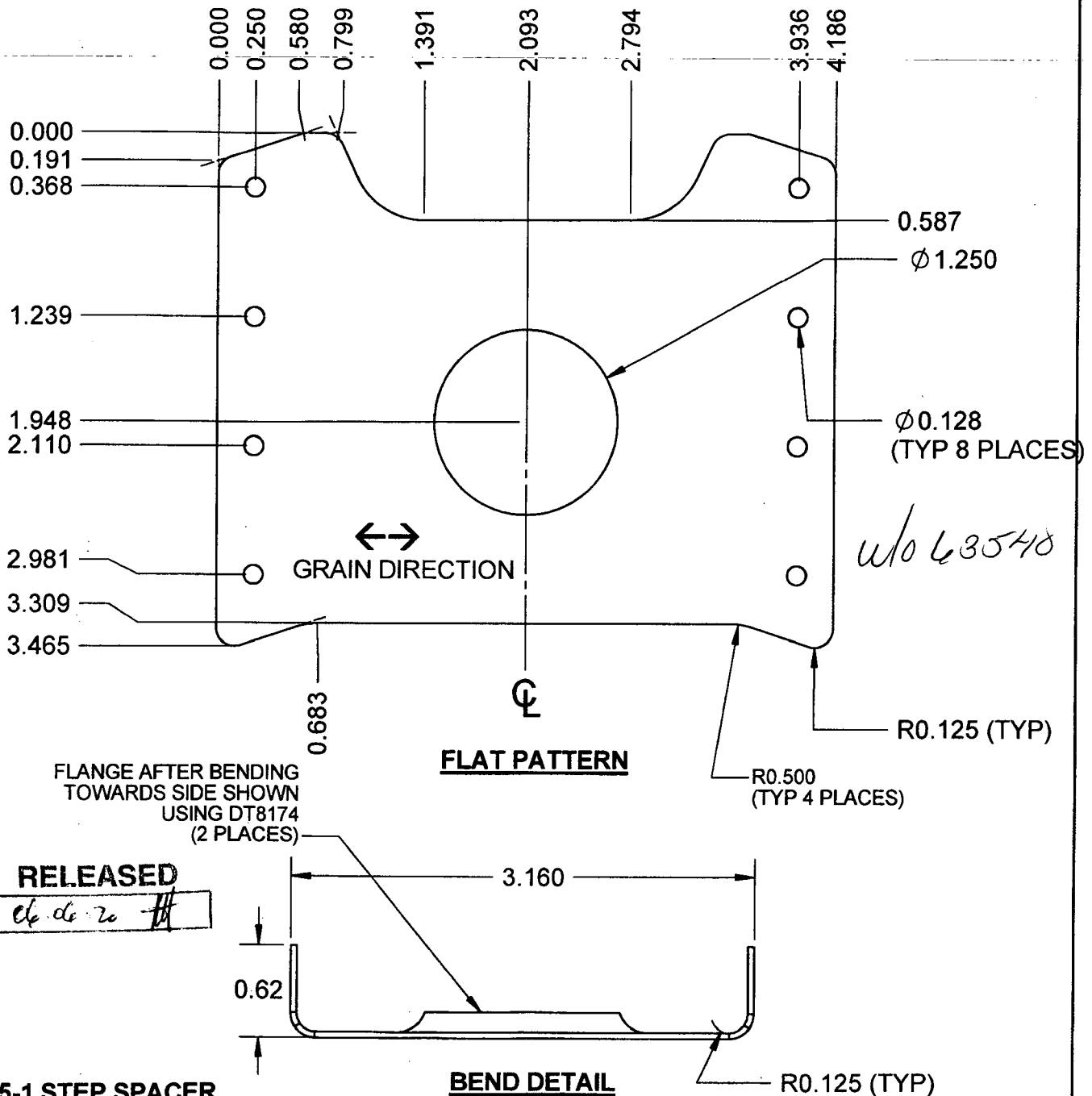
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CHECKED <i>PH</i>	APPROVED <i>#</i>	DRAWING NO. D3065	REV. B SHEET 2 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

**D3065-1 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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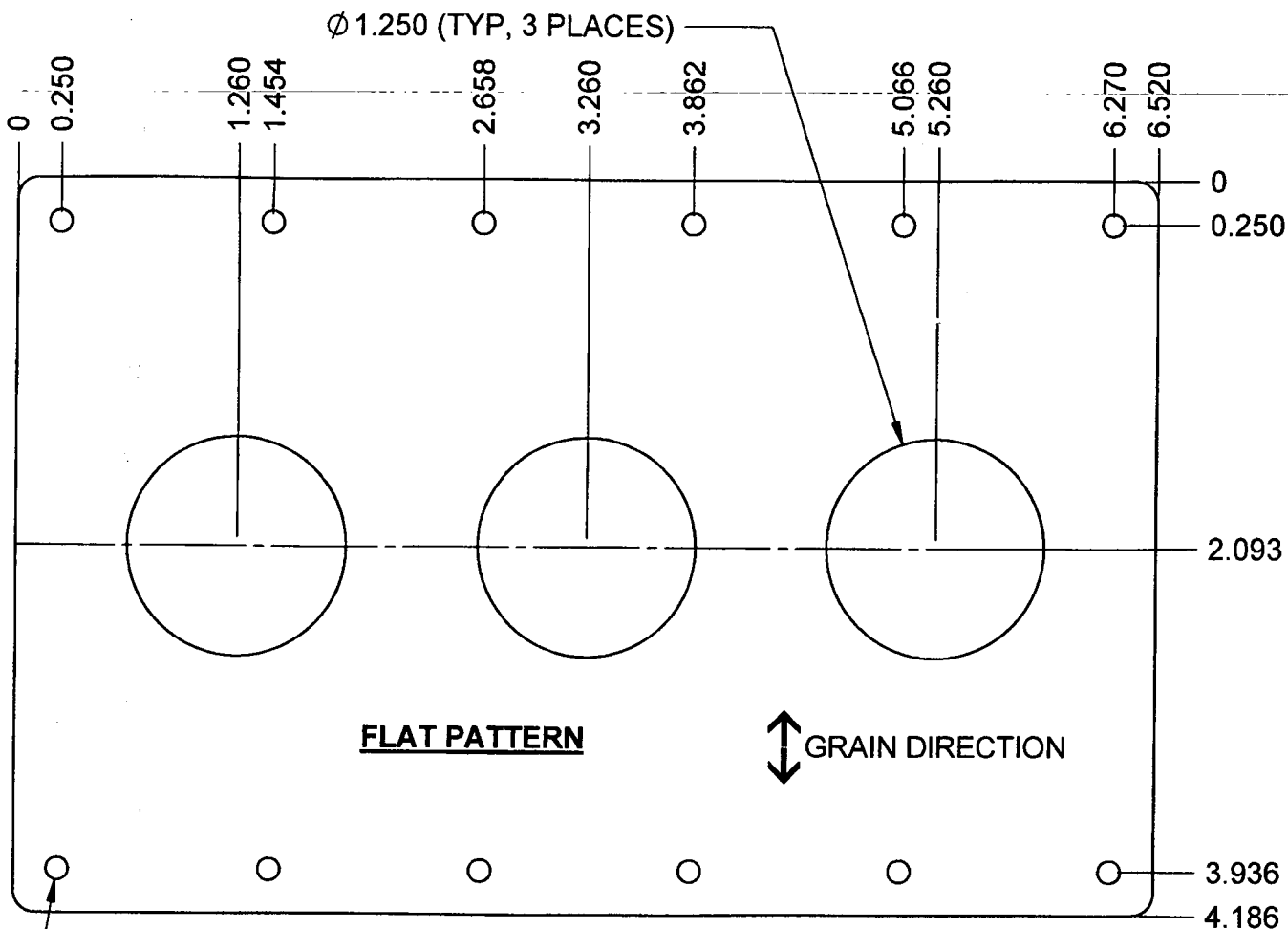
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B
DATE 06.05.23	TITLE STEP LEG ASSEMBLY		SHEET 3 OF 5 SCALE 1:1

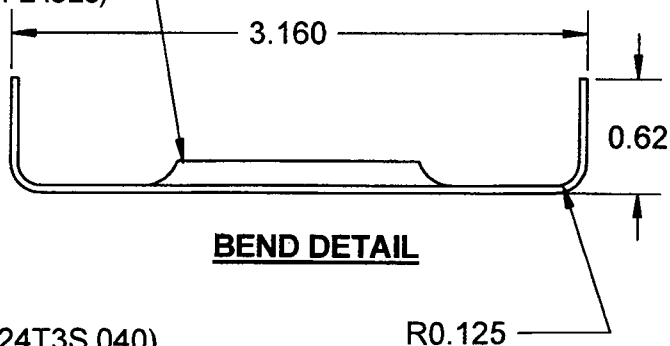
W1043540

FLANGE AFTER TOWARDS SIDE
SHOWN USING DT8174 (3 PLACES)

Ø 0.129 (TYP, 12 PLACES)

RELEASED

06.06.20



D3065-3 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

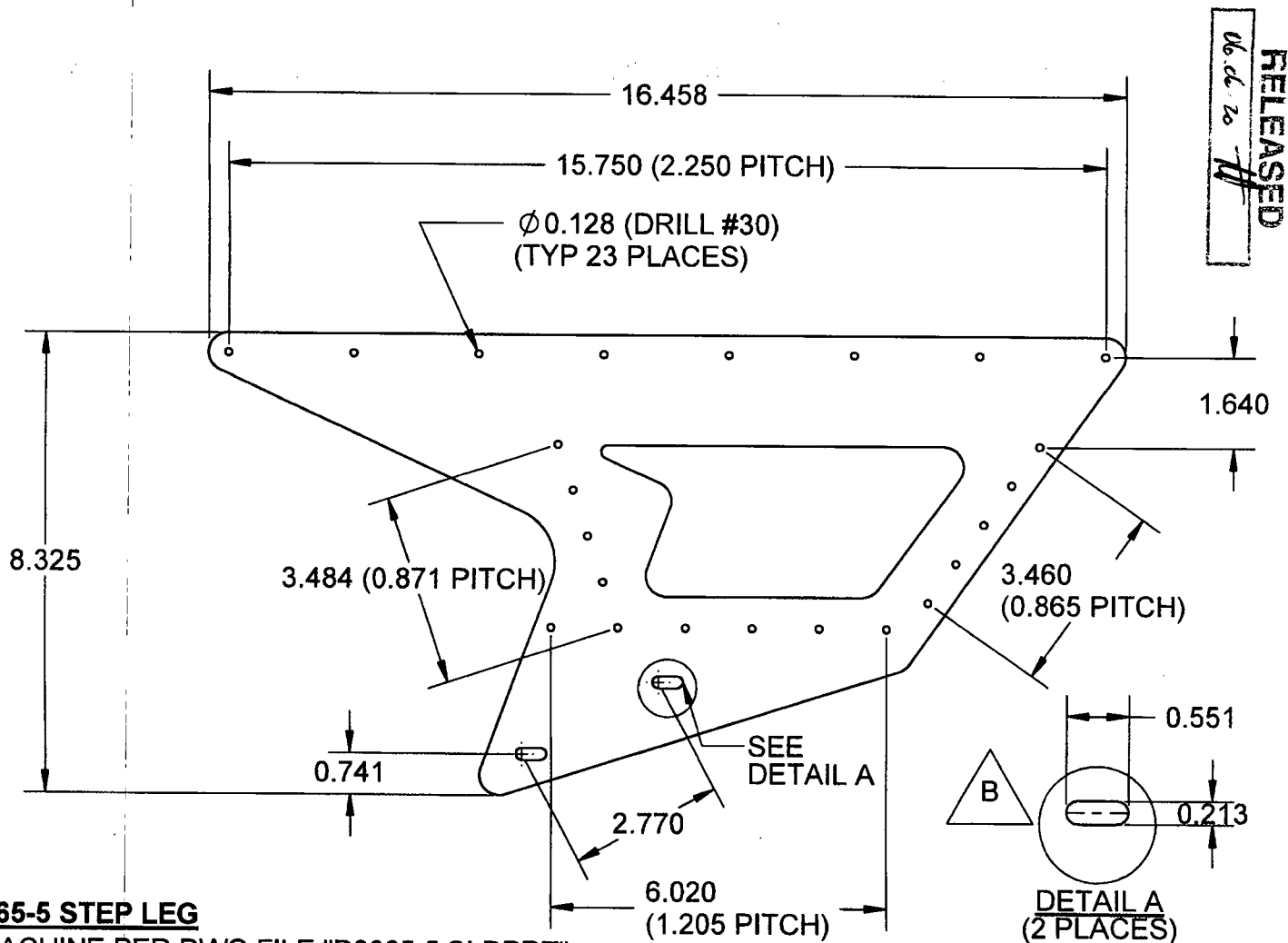
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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CHECKED	PH	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	06.05.23	TITLE	REV. B
		STEP LEG ASSEMBLY	SHEET 4 OF 5
			SCALE 1:3



D3065-5 STEP LEG

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRJT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
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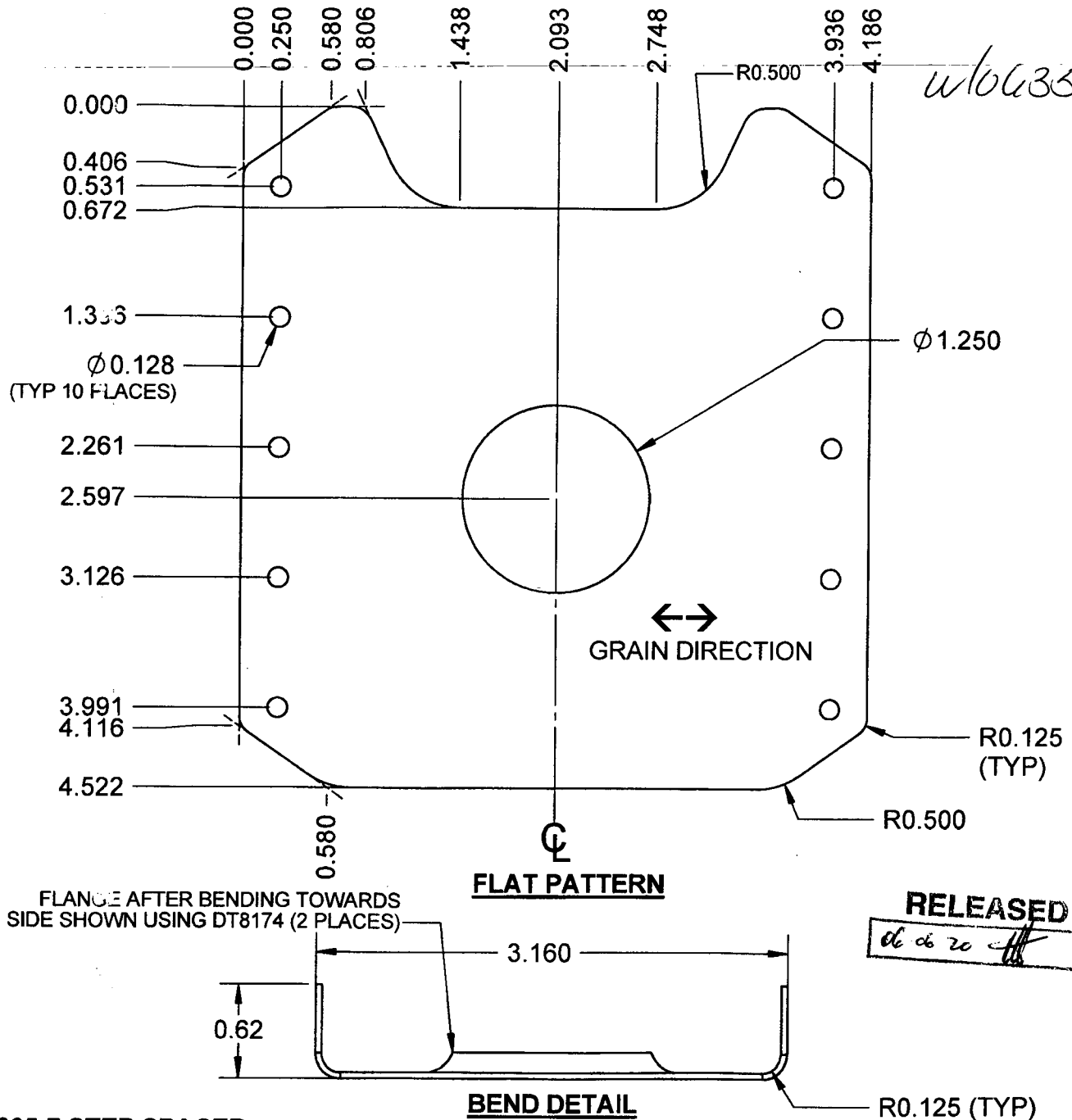
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 5 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

**D3065-7 STEP SPACER**

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
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